

Work Order ID 105622

Thursday, August 08, 2013 2:37:03 PM

105622

Page 1

Item ID: D3183-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearing

Start Date: 8/8/2013 Start Qty: 40.00

Required Date: 8/22/2013 Req'd Qty: 40.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *MLJ*

Date: *13-08-09*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *20888* Bearing as per Dwg D3183 Single row, deep groove, Conrad type, shielded Possible Supplier: NSK P/N 6800ZZ Certificate of conformity note is required

CL 13/08/12 (100)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

100X

*SP
B-8-B.*

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

*21
B & B*

*100
OK*

35

Work Order ID 105622

Thursday, August 08, 2013 2:37:03 PM

105622

Page 2

Item ID: D3183-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bcaring

Start Date: 8/8/2013 Start Qty: 40.00 ***40***

Required Date: 8/22/2013 Req'd Qty: 40.00 ***40***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Identify as per dwg & Stock Location: ST235B 0.00

130

Packaging

Memo

0.00

Packaging

100x

SP
13-8-13

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

ML5 13-08-14

QC 13-8-14

Picklist Print

Thursday, August 08, 2013 2:37:07 PM

Page 1

Work Order ID: 105622

Parent Item: D3183-5

Parent Item Name: Bearing

105622

D3183-5

Start Date: 8/8/2013

Required Date: 8/22/2013

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A03.03.27New issueKJ/RF

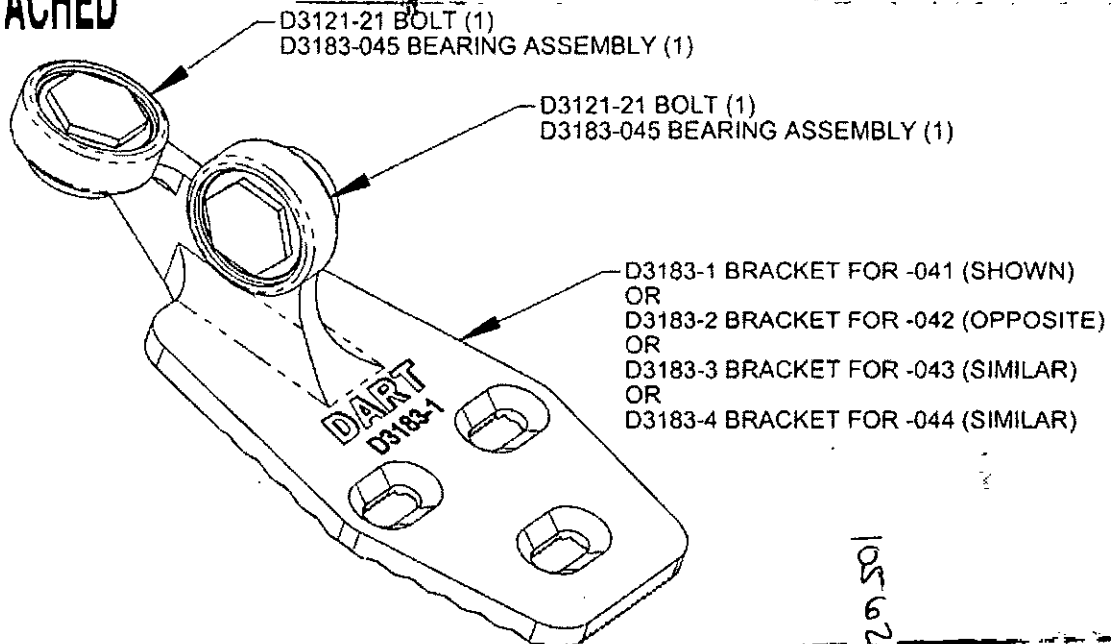
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6800ZZ		Purchased	No			100	Each	0.0000	1	100			
680077									**				
Bearing													

100 x Sp 13-8-13.

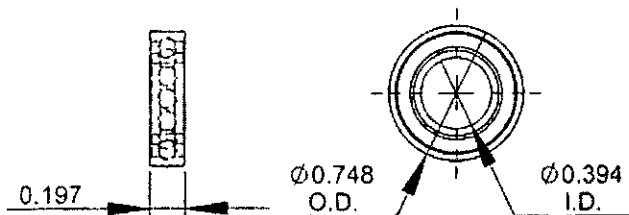


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:1	
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

RELEASED
04 03 01
DEO ATTACHED

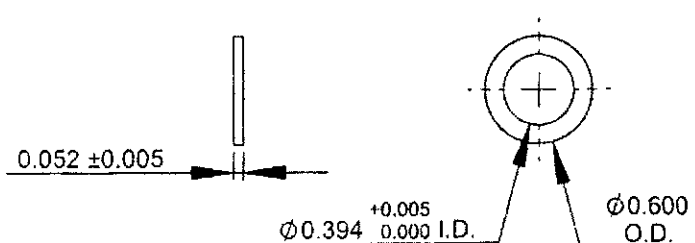


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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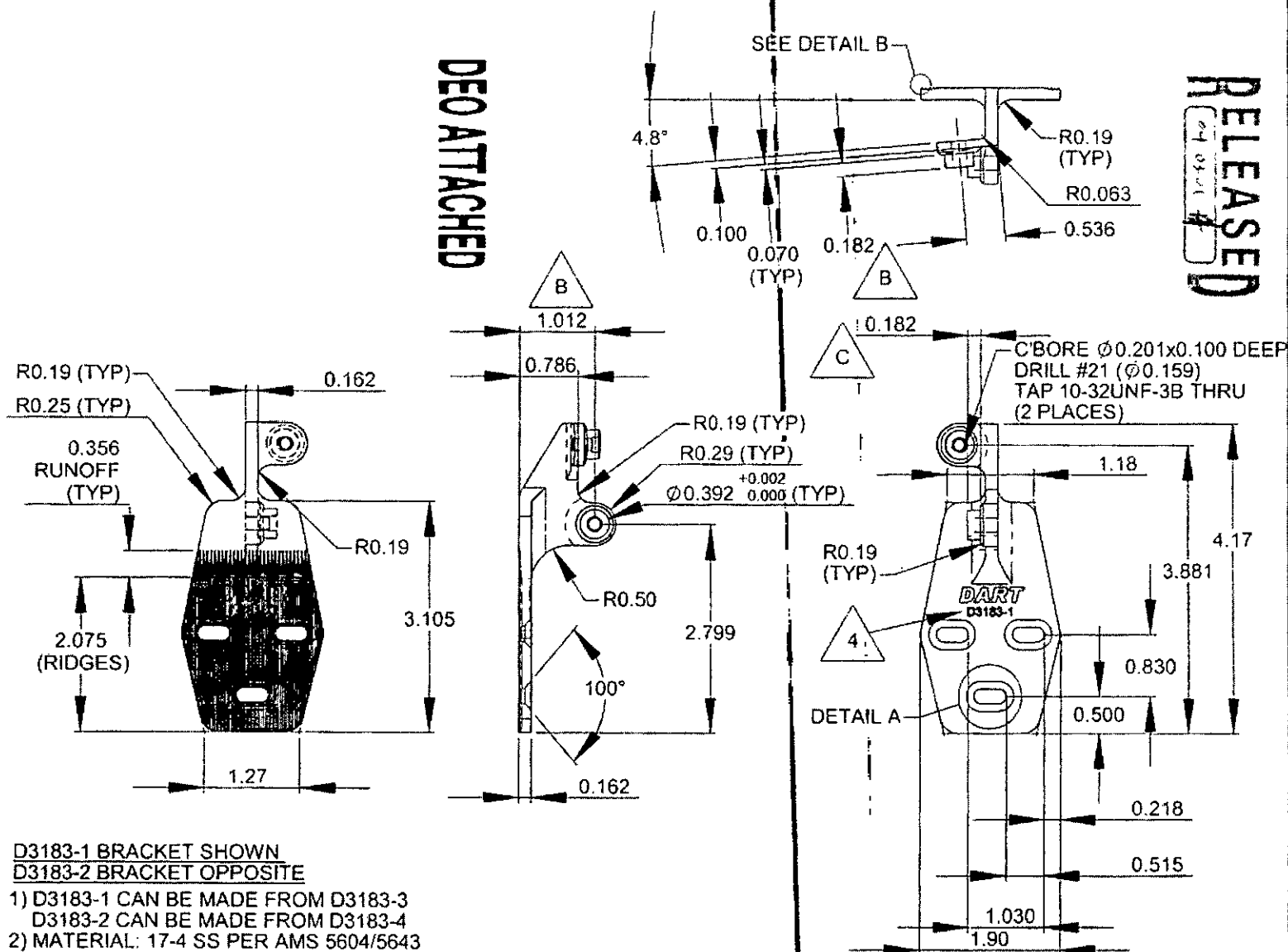
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DART

COPIES

DESIGN	DRAWN BY	DARI AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 2 OF 4
DATE		TITLE	SCALE
04.02.17		BRACKET ASSEMBLY	1:2

04 03 01



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

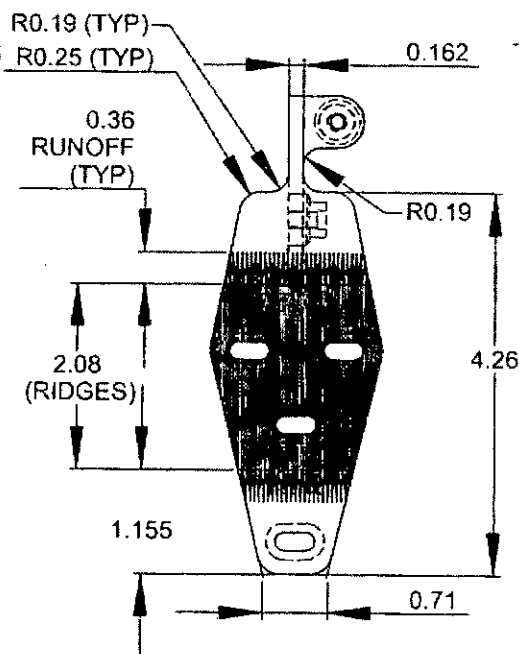
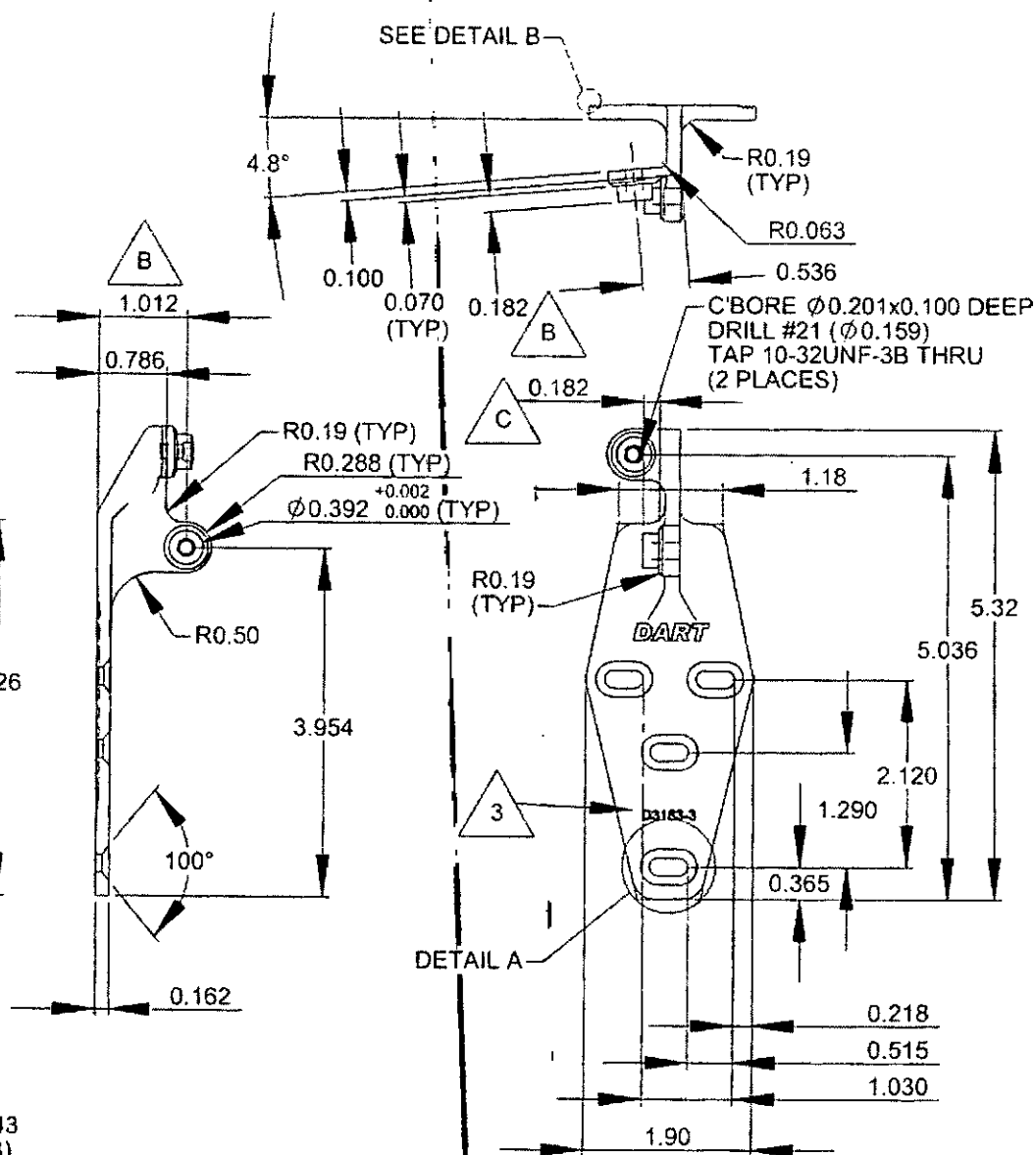
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107622



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 04.02.17	DRAWING NO. D3183	REV. C
	TITLE BRACKET ASSEMBLY	SHEET 3 OF 4
		SCALE 1:2



- D3183-3 BRACKET SHOWN**
(REPLACES BELL P/N 412-030-304-105)
- D3183-4 BRACKET OPPOSITE**
(REPLACES BELL P/N 412-030-304-106)
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
 - 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
 - 3) ENGRAVE DART P/N & LOGO AS SHOWN
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES

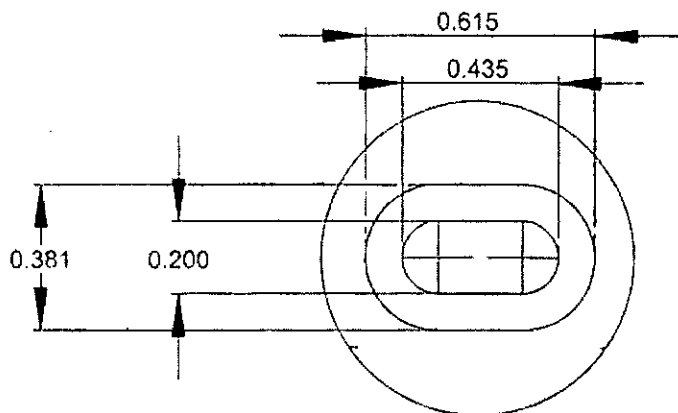
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DEATTACHED
RELEASED
04-03-01-4



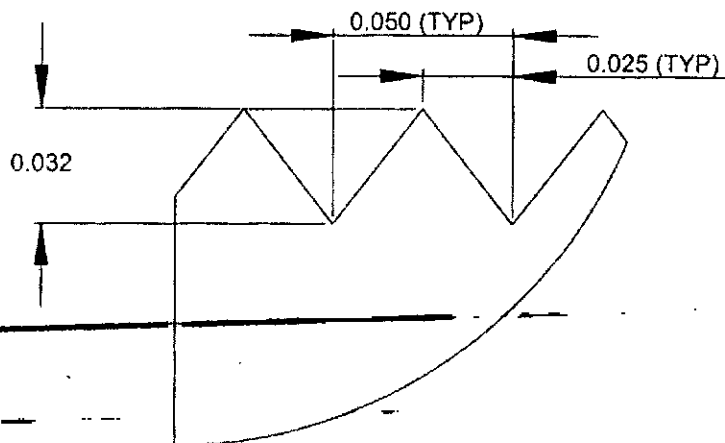
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1



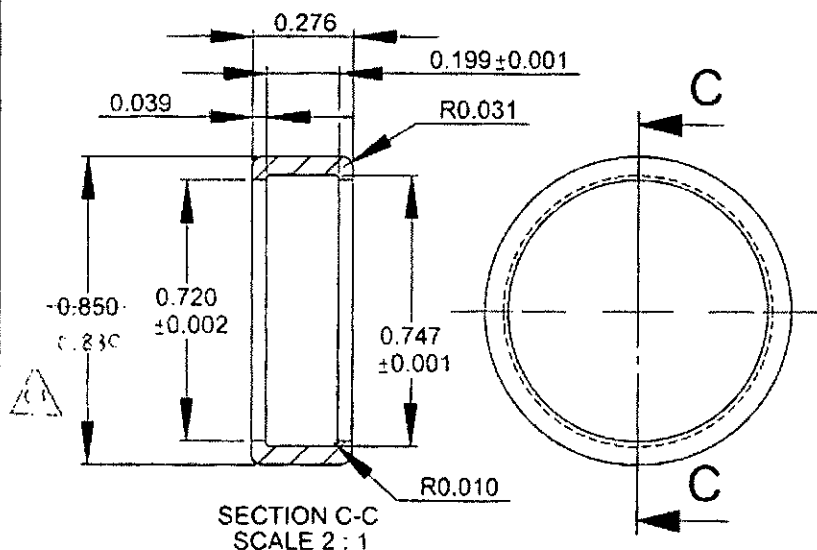
DETAIL A (2 : 1)

RELEASED
04 03 01

DEO ATTACHED



DETAIL B (20 : 1)



SECTION C-C
SCALE 2 : 1

D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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107622

105622

DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN qp	CHECKED [Signature]	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED
2010-07-22
[Signature]

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**1475 TESSIER ST.
HAWKESBURY ON K6A 3S6
Phone: (613) 632-3595 Ext. Fax: (613) 632-0262
sales@mainindustrialsales.com**

DATE August 13, 2013
NUMBER 0000164895
CUSTOMER NO. DART

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON K6A 1K7

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON K6A 1K7

(613) 632-5200 Ext.

P.O. NUMBER	SALESPERSON	ORDER DATE	REQ. DATE	ORDER NUMBER
20888	EB	12-Aug-13		0000164895
F.O.B.	SHIP VIA		TERMS	
F.O.B. value	OUR TRUCK / LOCAL		NET 30 DAYS	
PART NUMBER DESCRIPTION		LOCATION	UOM	QUANTITY REQ. SHIPPED B.O.
0-68002ZKML BALL BEARING YOUR PART #: 6800ZZ		6D6	EA	✓ 100 100
				GPB-8-13



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20888

Purchase Order Date 8/12/2013

PO Print Date 8/12/2013

Page Number 1 of 1

Order From :

VC-MAI001

Ship To : DART AEROSPACE LTD

MAIN INDUSTRIAL SALES LTD.
1475, TESSIER
HAWKESBURY, ON K6A 3S6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
8/13/2013

Contact Name

Vendor Phone

613 632 3595

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Yours ppd

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	6800ZZ	Bearing	8/15/2013 Yes 8/15/2013		✓ 100.00 Each	\$1.48	\$148.00

AS PER DWG D3183 REV. C

B105622

SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
NSK P/N: 6800ZZ

Line Total: \$148.00

PO Total: \$148.00

SP 13-8-13

CL ML

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required - YES NO

PST# 6122-5207

Change Nbr: 1

Change Date: 8/12/2013

